

Date: Tuesday, 5/23/2006 8:36:21 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 27204B		
Estimate Number	: 10339		
P.O. Number	: N/A	Part Number	: D2658
This Issue	: 5/23/2006 S.O. No. : N/A	Drawing Number	: D2658 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D
Previous Run	: 26802	Material	: N/A
Written By	: See comment below	Due Date	: 6/10/2006
Checked & Approved By	: JLM	Qty:	30 Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <u>1312</u> Laser cut per Drawing Flat pattern D2658 Material release note required
2.0	D2658F	Lug Bracket
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s) Lug Bracket
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK Inspect dimensions per template D2658T1
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Deburr as required. 2-Bend on CNC brake using DT8254 Identify as D2658

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

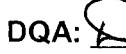
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: Date: 06/08/01

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27204B

Part Number: D2658

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Job 07.20

(30)

Comment: INSPECT WORK TO CURRENT STEP

7.0 DC

DOCUMENT CONTROL



(30)

Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/08/01

Job Completion



KJ 06.08.01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

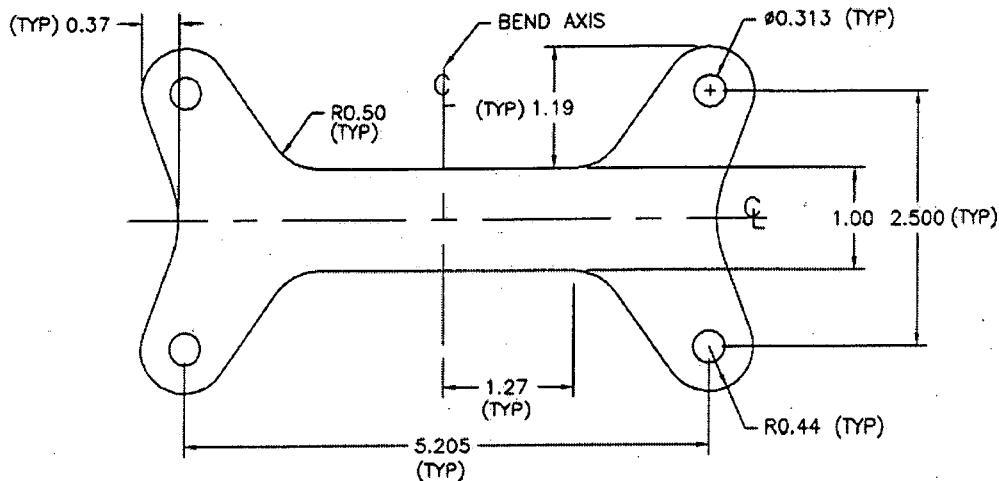
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

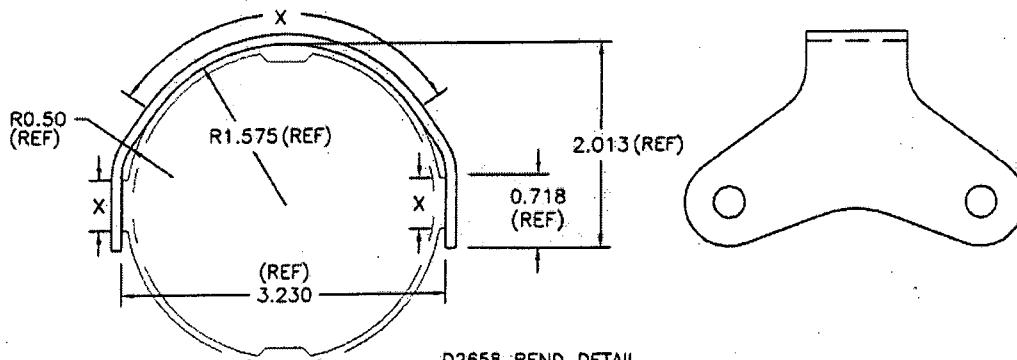
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DARTCOPY ISSUED
TO

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2658	REV. D SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS

D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (C)



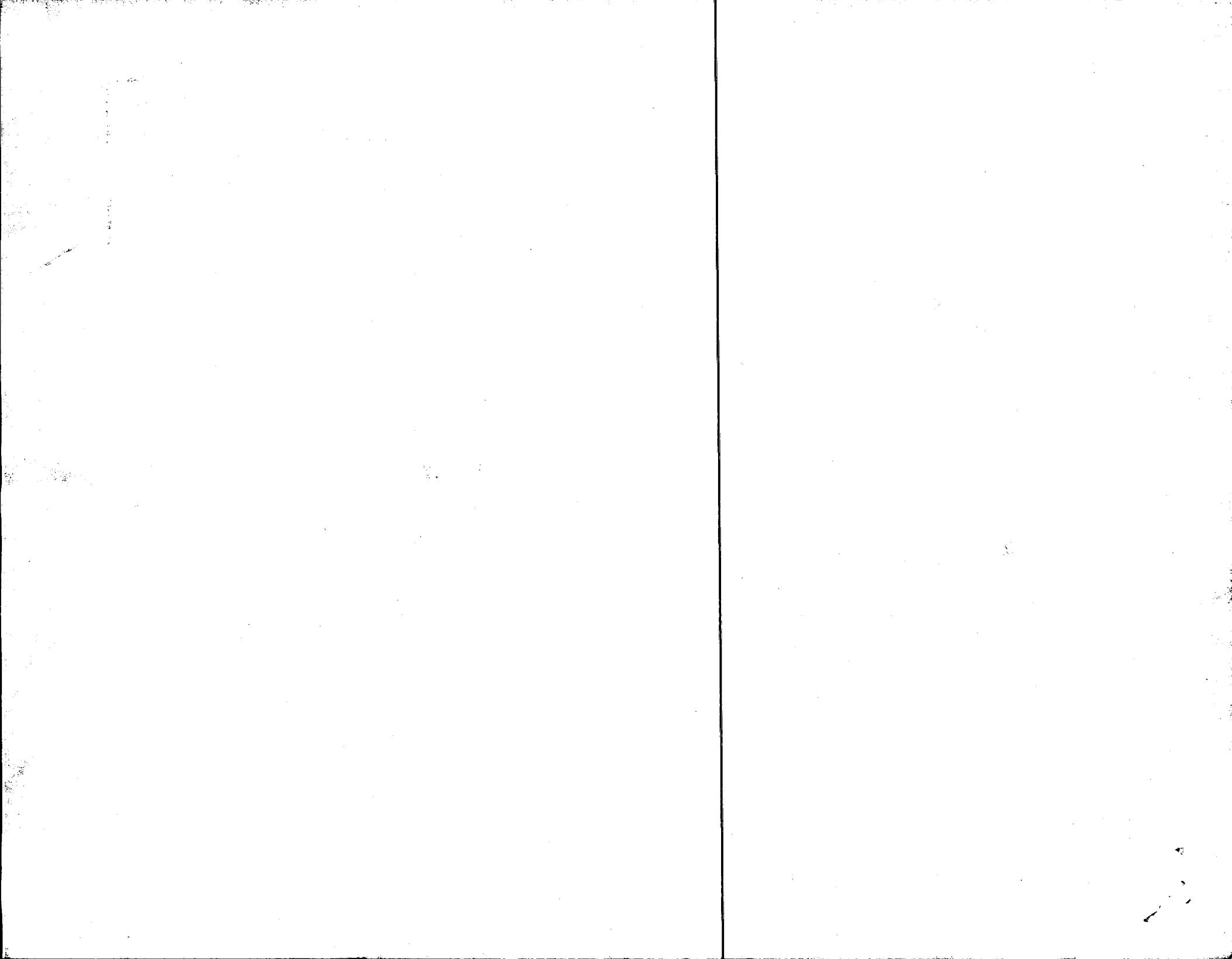
D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES
MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 272-D-B





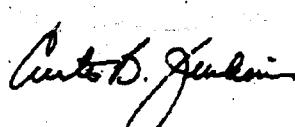
DO: 227168
REV: 551013 MO
California Steel Industries
14000 San Bernardino Ave.
Fontana, California 92335
Ph (909) 350-6300

CERTIFIED TEST REPORT

8

CUSTOMER ORDER P50614ME002		MO. NUMBER 02-8344-01	SHIPPING DATE 08/01/05	CAR NUMBER RR: WCTR142061	TALLY NUMBER PO 250499136 1 /
B I L L T O	WILKINSON STEEL AND METALS A DIVISION OF PREMETAL CO., INC. 888 S.E. MARINE DR., VANCOUVER BC, CANADA, V5X2V3	S H I P T O	WILKINSON STEEL-METALS C/O GARY R. HAMILTON TRUCKING 888 S.E. MARINE DR., VANCOUVER BC, CANADA	BC	VSY 2

MARK ALL DOCUMENTS W/P.O. P50614ME002. FAX TALLIES AT TIME OF SHIPMENT TO MEL ELIAS FAX #604-301-3244.

END USE	WAREHOUSE STOCK - NON-CRITICAL SURFACE				
PROD	H.R. COILS - P & O - PRIME				
SPEC	ASTM-A-1011-00-CS-TYPE B				
T/R	INSPECTION MILL				
	DESCRIPTION	COILS, PIECES OR BUNDLES	HEAT NUMBER		
	.0605 x 48.0000 x COIL NOM ME	1 1	T42354 T42348		
					I CERTIFY THE FOLLOWING TEST INFORMATION TO BE CORRECT AS CONTAINED IN THE RECORDS OF THE COMPANY.
					
					CHIEF - LABORATORY SERVICES

MECHANICAL PROPERTIES				CHEMICAL ANALYSIS												10:48:05 08/01/05 CC						
HEAT OR LOT NUMBER	SLAB NUMBER	LOC	YIELD KSI	TENSILE STRENGTH KSI	% ELONGATION		BEND TEST	C	Mn	P	S	S1	Cu	Ni	Cr	Mo	Al	V	Cb	T1	N	
					B"	Z"																
T42354							08	.39	.010	.006	.006	01	01	01	00	.050	000	000	000	002		
T42348							08	.38	.014	.010	.007	01	01	01	00	.046	000	000	001	003		

CTR-001 PTLUC22L 980712



New Zealand Steel Limited
Glenbrook, South Auckland
Postbox Private Bag 92121, Auckland, New Zealand
Telephone: (09) 375 8599 / 375 8111 Auckland
(09) 235 8009 / 235 2555 Warkworth
Fax: (09) 375 8599

TEST CERTIFICATE

Ref: 581226003

CUSTOMER		Weldmax		SPECIFICATION												ASTM A191M/LCS-TYPE B		CERTIFICATE NO.		TC124640					
CUSTOMER ORN		98-314-108		PRODUCT												HOT ROLLED PICKLED & OILED		PAGE		1 of 1					
MILL ORN		S18691		DIMENSIONS												0.750" x 48" x 6'0"		DATE		17 January 2006					
CHEMICAL COMPOSITION PERCENT																									
PACK NUMBER	Sample	MEAT No	C	S	Mn	P	S	CU	Ni	Cx	Mo	V	Nb	Ti	Al	B	H2	CE(L)	BEND	YIELD	T.S.	ELONG	HARDNESS	L	LENGTH (mm)
			x100			x1000				x1000						x10000	x100	180°							
HIP-997711-00	646664	6	1	20	9	19													Good					942	961
HIP-997712-00	646664	6	1	20	9	19													Good					955	955
HIP-997713-00	646846	5	TR	20	11	19													Good					955	955
HIP-997714-00	646846	5	TR	20	11	19													Good					955	955
HIP-997715-00	646664	6	1	20	9	19													Good					955	955
HIP-997716-00	646664	6	1	20	9	19													Good					958	958
HIP-997717-00	646846	5	TR	20	11	19													Good					958	958
HIP-997718-00	646846	5	TR	20	11	19													Good					958	958
HIP-997719-00	646846	5	TR	20	11	19													Good					958	958
HIP-997720-00	646846	5	TR	20	11	19													Good					958	958
HIP-997721-00	646846	5	TR	20	11	19													Good					958	958
HIP-997722-00	646846	5	TR	20	11	19													Good					958	958

YIELD
(A)=0.2% PROOF STRESS
(B)=LOWER YIELD STRESS

GAUGE LENGTH (G.L.)
(A)=200mm (C)=80mm (E)=2"
(B)=50mm (D)=5.65 : 50 (F)=8"

PLASTIC STRAIN RATIO (I)
(A)=0 (C)=1.5 (E)=14
(B)=1.0 (D)=(Mn+Ni)/245 (F)=

IMPACT TEST
(A)=10mm x 10mm
(B)=7.5mm x 10mm
(C)=5mm x 5mm

(D)=2.5mm x 10mm
(E)=5mm x 10mm

CARBON EQUIVALENT VALUE (CE)
(A)=C + Mn/2 + Ni/24
(B)=C + Mn/2 + (Cr + V + Mo + Ti + Cu + Nb)/15

(C)=C + Mn/2 + Si/24
(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Barish Misra*
QC METALLURIST

